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Tsunoda

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(54) **SHEET PROCESSING APPARATUS AND IMAGE FORMING SYSTEM**

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B42B 4/00	(2006.01)
B65H 37/04	(2006.01)
G03G 15/00	(2006.01)

(52) **U.S. Cl.**

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(58) **Field of Classification Search**

CPC B65H 5/32; B65H 37/04; B65H 2801/27; B65H 2408/121; B42C 1/12; G03G 15/6541

USPC 270/37, 52.18, 52.26, 58.08, 58.09

See application file for complete search history.

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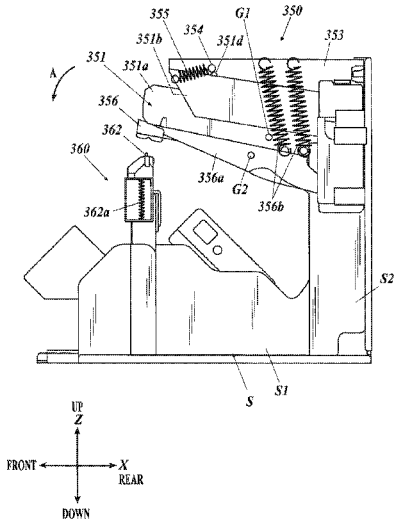
Primary Examiner — Leslie A Nicholson, III

(57) **ABSTRACT**

A sheet processing apparatus including: an accumulating section on which a sheet is accumulated; a staple inserting section which is provided above the accumulating section; a staple receiving section which is provided so as to face the staple inserting section across a sheet bundle accumulated on the accumulating section; and a movement section which moves an inserting unit or the accumulating section according to a thickness of the sheet bundle so that the inserting unit faces a predetermined position on an upmost sheet of the sheet bundle, wherein the staple inserting section includes the inserting unit which inserts a staple into the sheet bundle by rotating toward the sheet bundle.

5 Claims, 12 Drawing Sheets



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English translation of Office Action dated Sep. 18, 2015 issued from the corresponding Chinese Patent Application No. 201410315777.7.

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FIG. 1

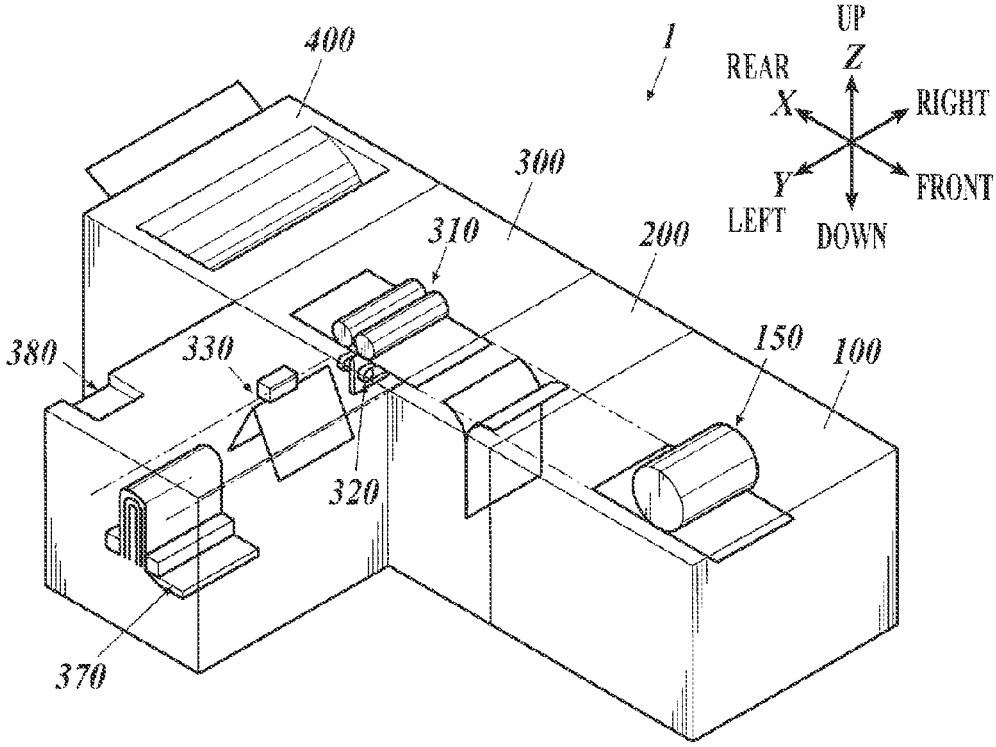

400
1
UP
Z
REAR
X
RIGHT
Y
FRONT
LEFT
DOWN
300
310
200
380
330
150
100
320
370

FIG. 2

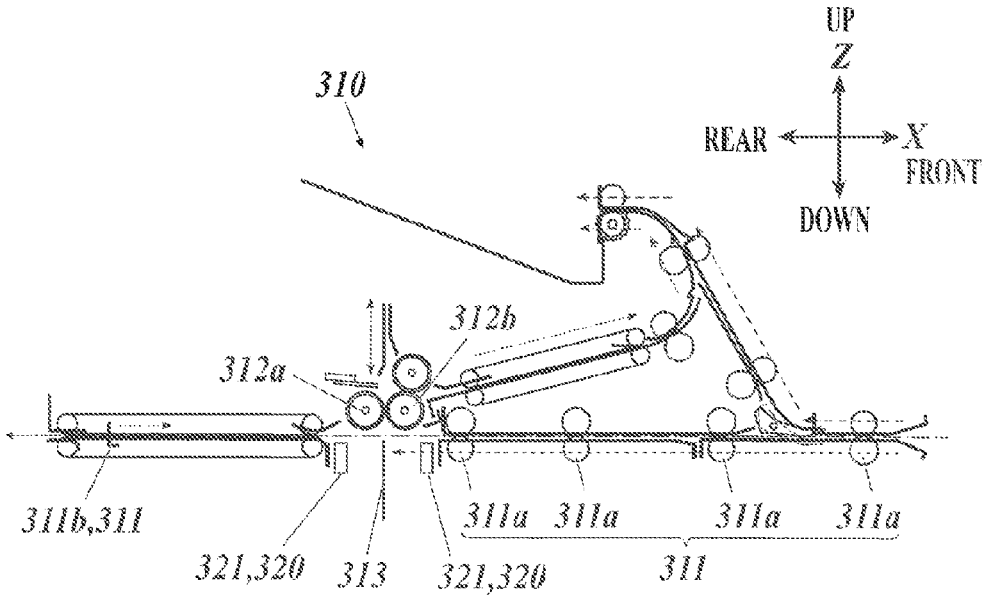

310
UP
Z
REAR
X
FRONT
DOWN
312b
312a
311b,311
321,320
313
321,320
311a
311a
311a
311a
311

FIG. 3

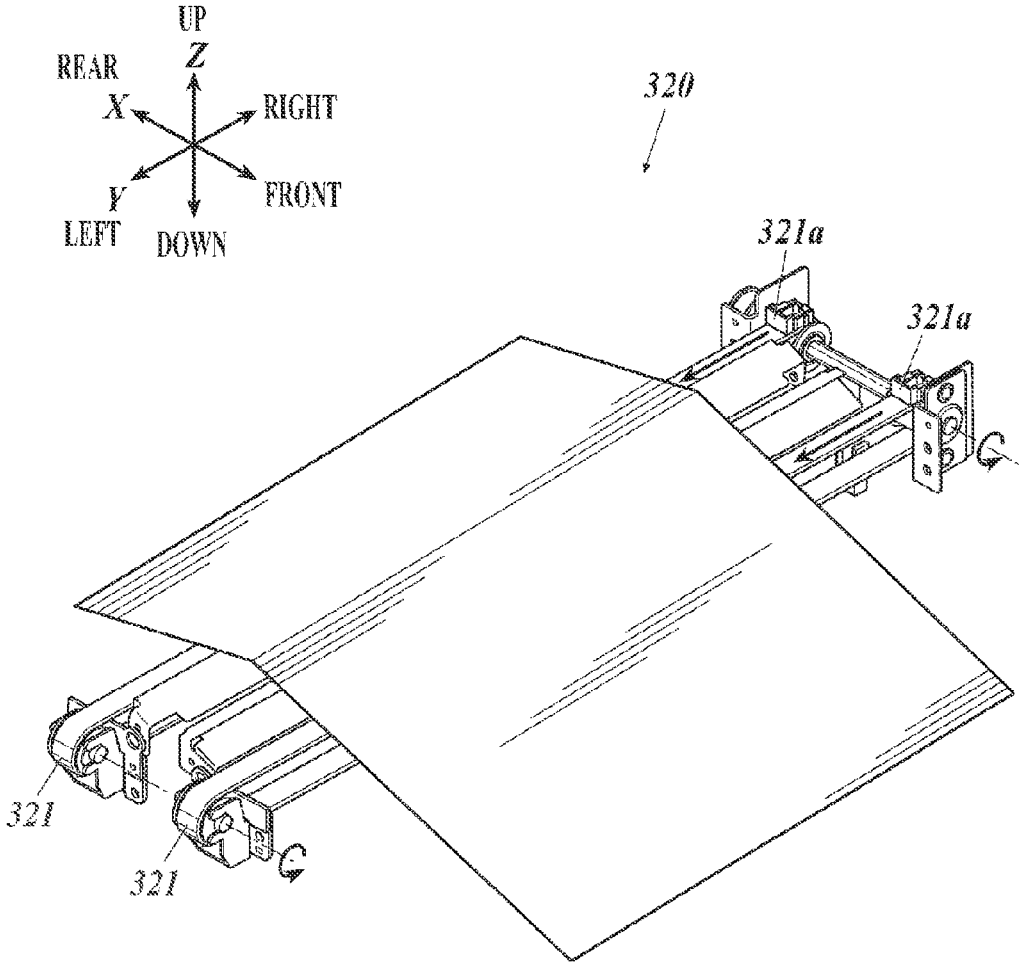


FIG. 4

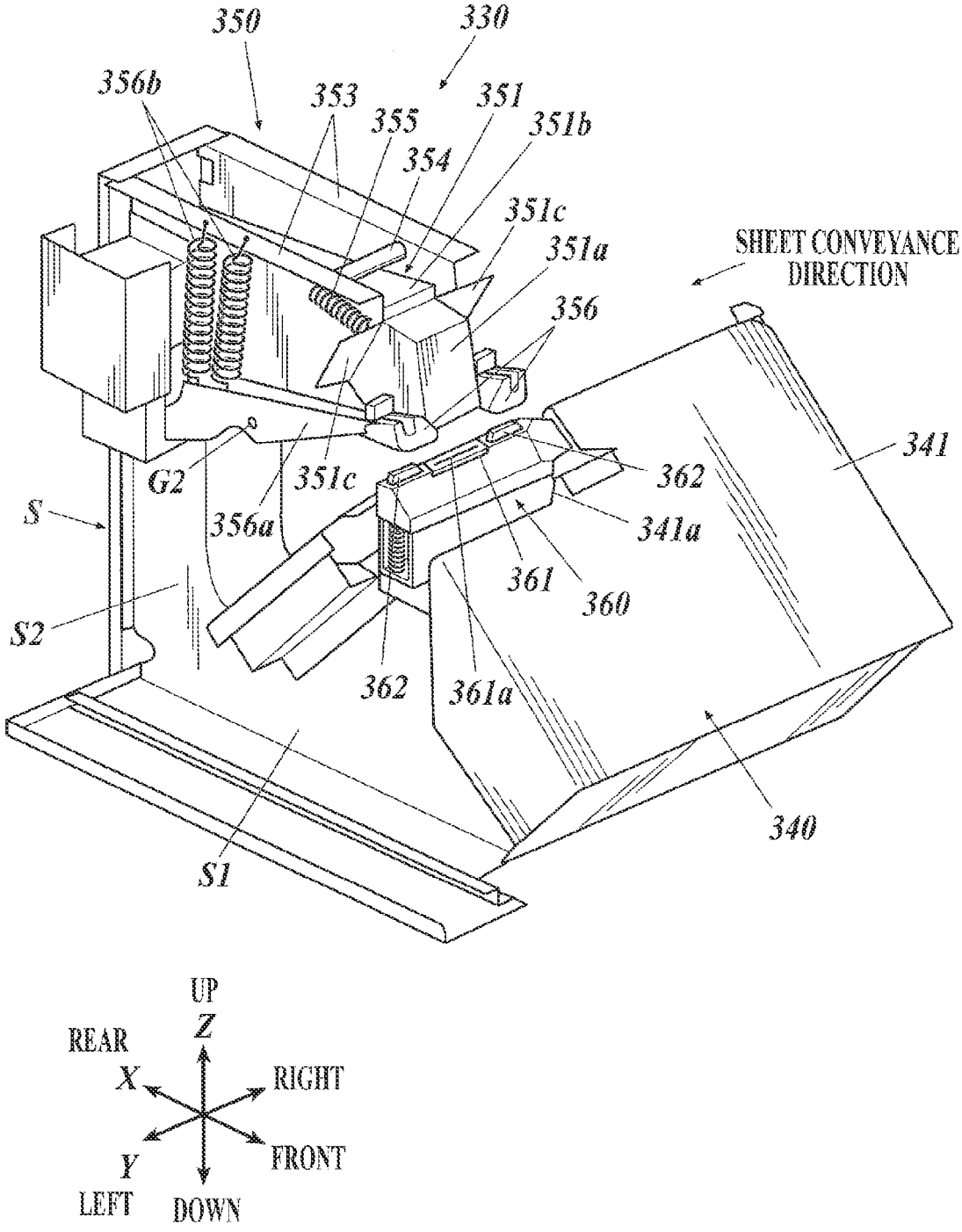
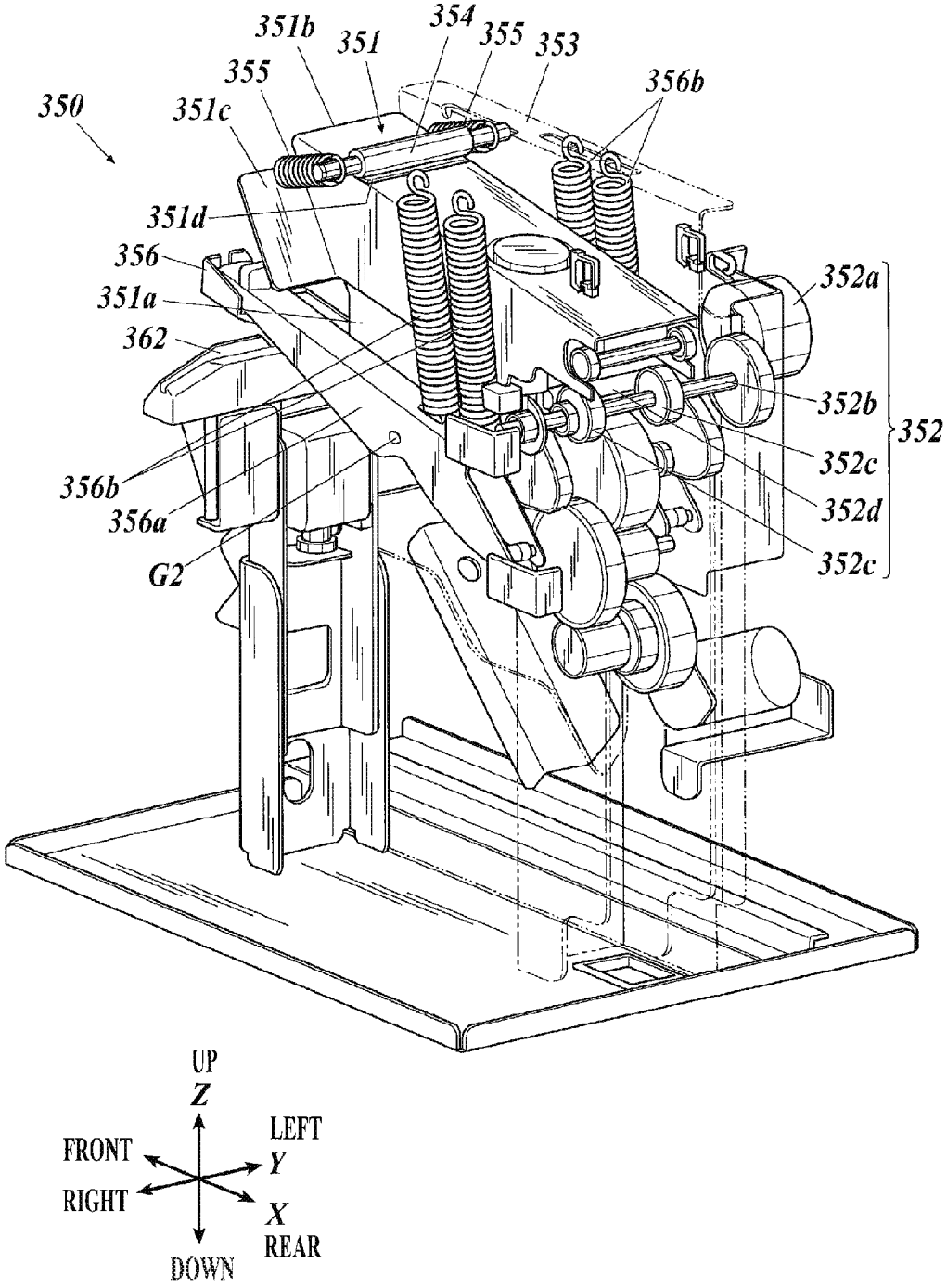

350
330
356b
353
355
351
351b
354
351c
351a
SHEET CONVEYANCE DIRECTION
356
341
G2
351c
362
S
356a
341a
361
360
S2
362
361a
340
S1
UP
Z
REAR
X
RIGHT
Y
FRONT
LEFT
DOWN

FIG. 5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351
354
355
353
355
351c
356b
351d
356
351a
362
352a
352b
352
352c
352d
352c
356b
356a
G2
UP
Z
LEFT
FRONT
Y
RIGHT
X
REAR
DOWN

FIG.6

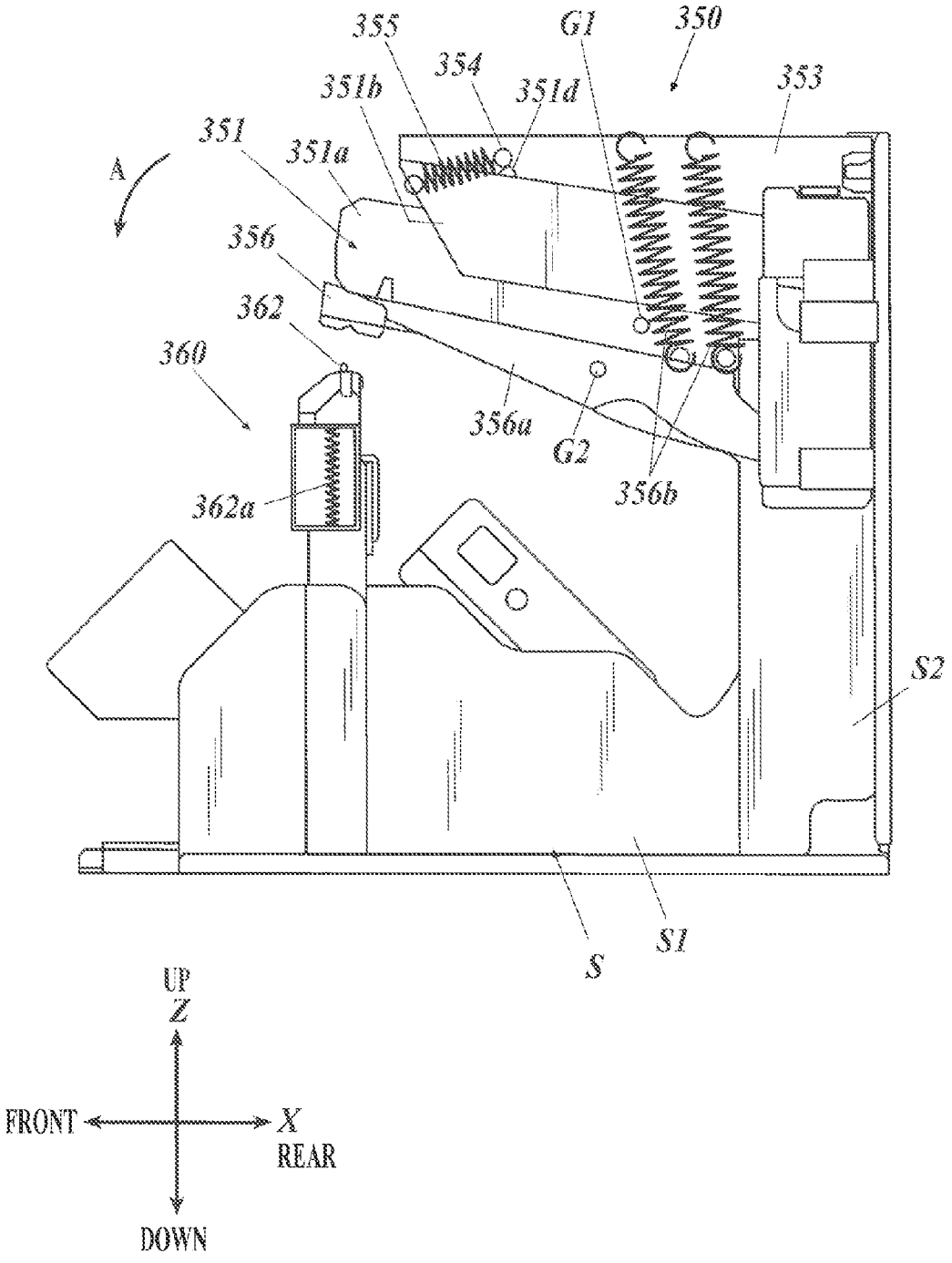

355
G1
350
354
351b
351d
353
351
351a
A
356
362
360
356a
G2
362a
356b
S2
S
S1
UP
Z
FRONT
X
REAR
DOWN

FIG. 7

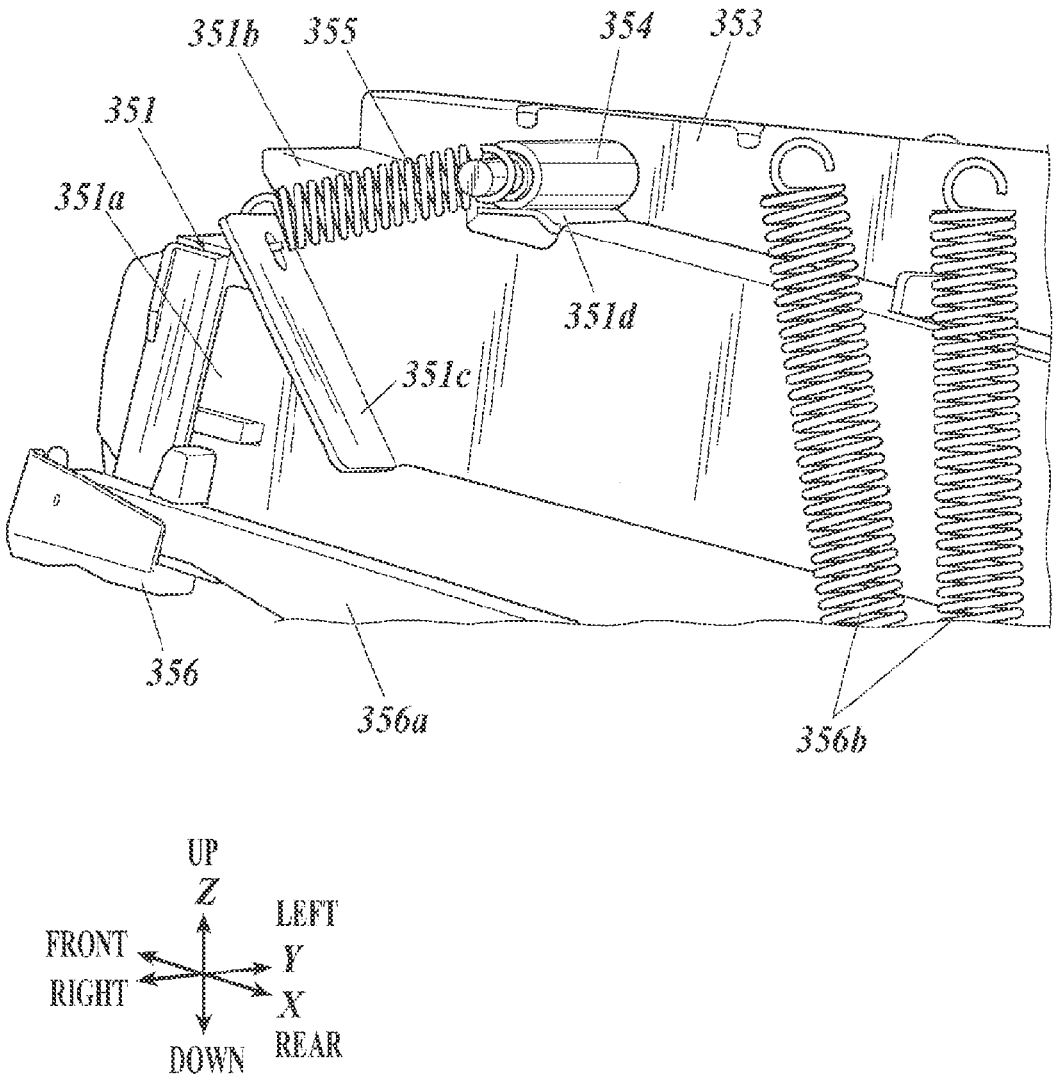

351b
355
354
353
351
351a
351d
351c
356
356a
356b
UP
Z
LEFT
FRONT
Y
RIGHT
X
REAR
DOWN

FIG. 8

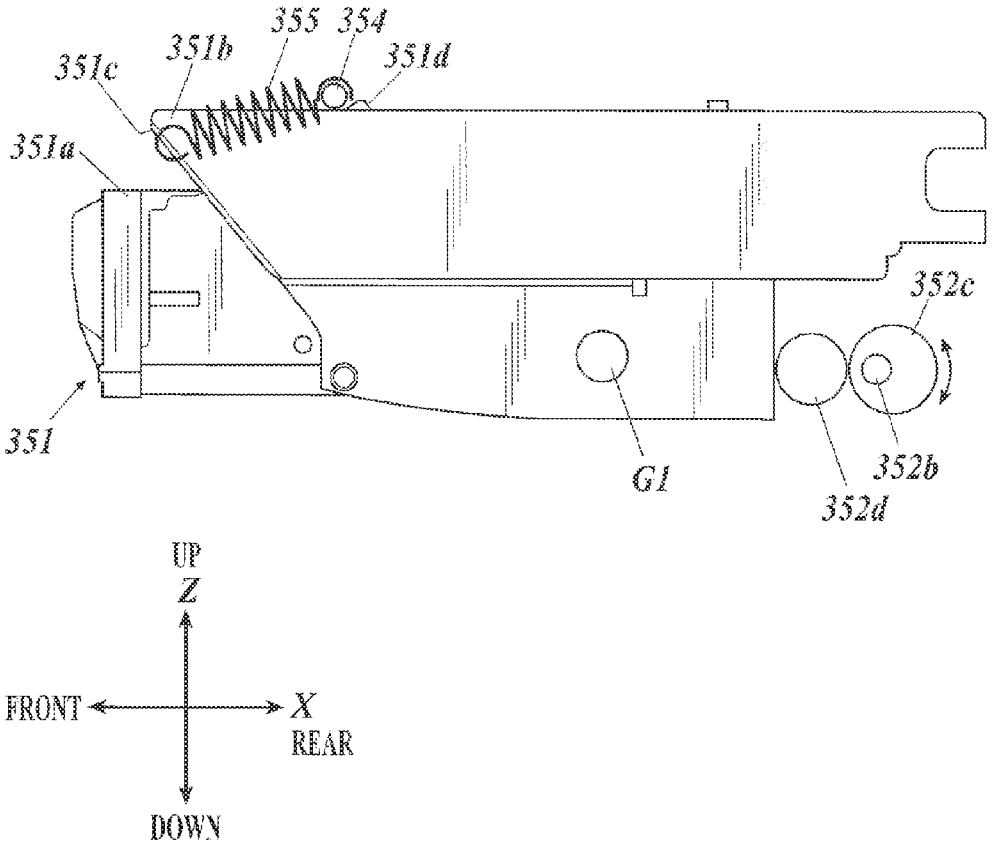
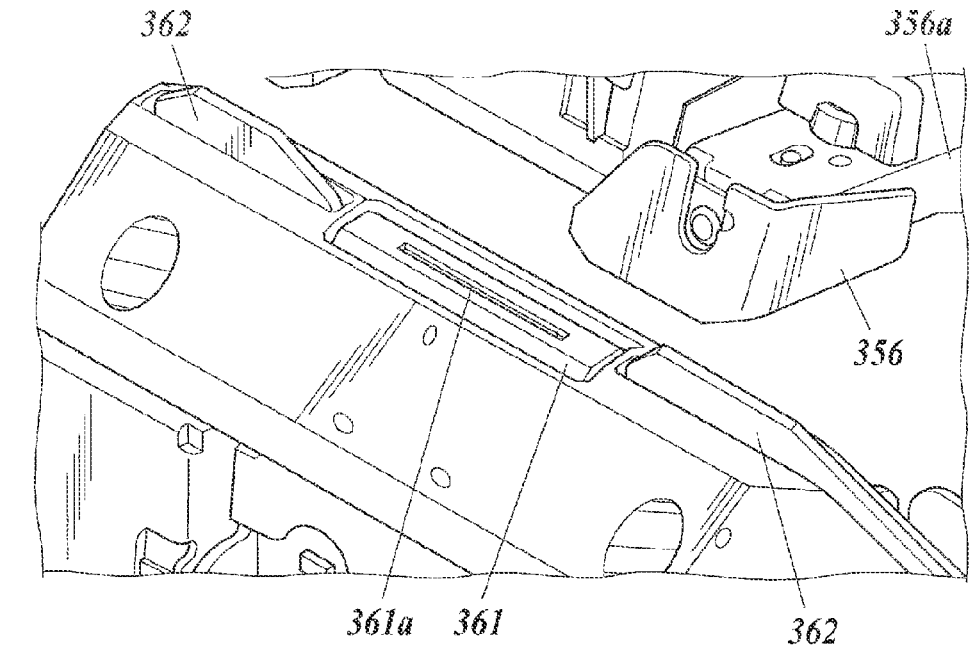

355
354
351b
351c
351d
351a
352c
351
G1
352b
352d
UP
Z
FRONT
X
REAR
DOWN

FIG. 9



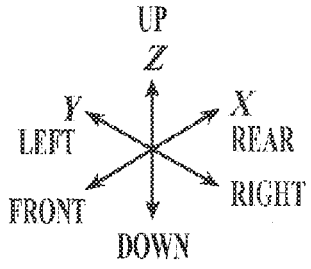


FIG. 10

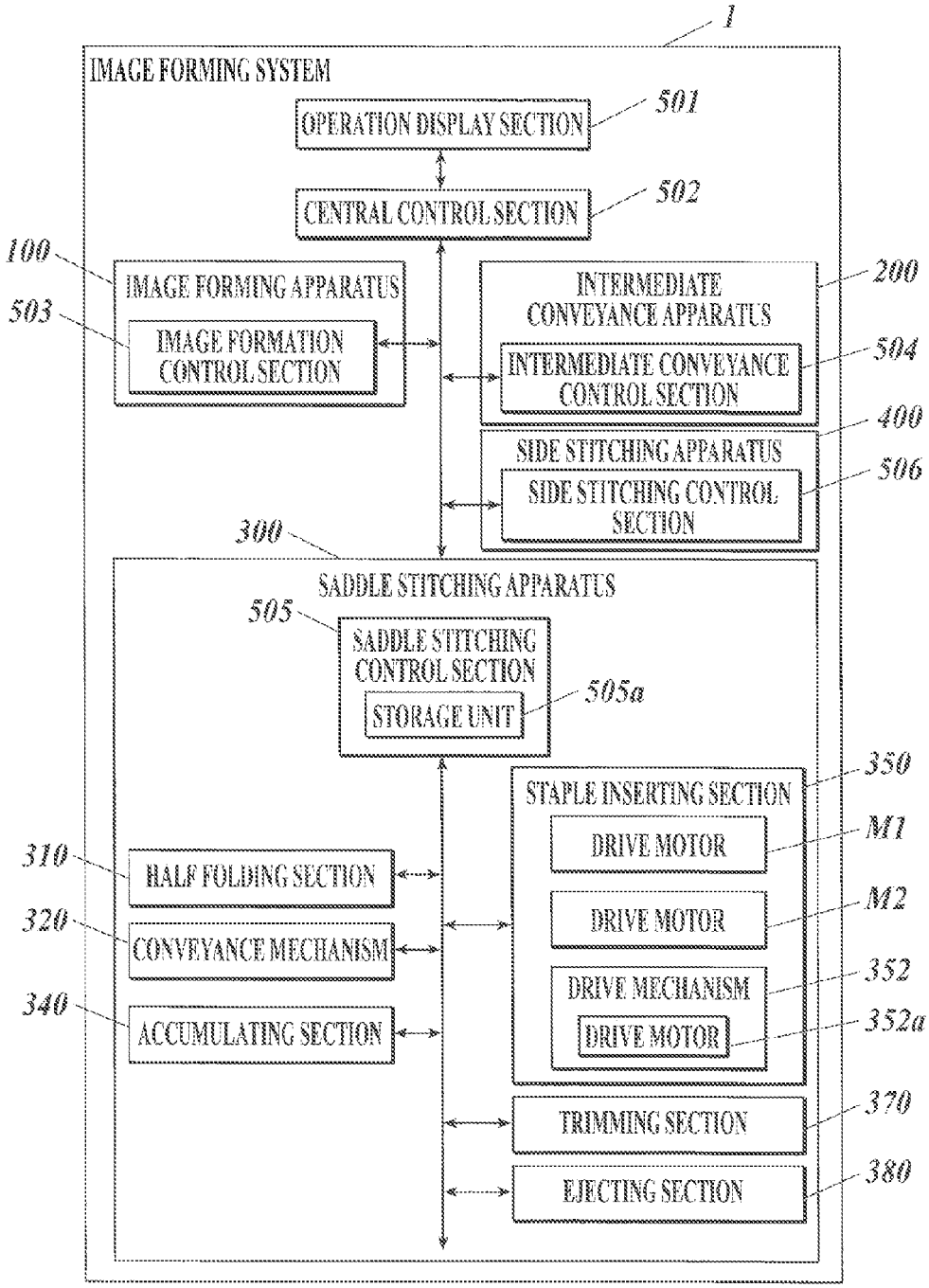

1
IMAGE FORMING SYSTEM
OPERATION DISPLAY SECTION
501
CENTRAL CONTROL SECTION
502
100
IMAGE FORMING APPARATUS
503
IMAGE FORMATION CONTROL SECTION
200
INTERMEDIATE CONVEYANCE APPARATUS
INTERMEDIATE CONVEYANCE CONTROL SECTION
504
400
SIDE STITCHING APPARATUS
SIDE STITCHING CONTROL SECTION
506
300
SADDLE STITCHING APPARATUS
505
SADDLE STITCHING CONTROL SECTION
STORAGE UNIT
505a
350
STAPLE INSERTING SECTION
DRIVE MOTOR
M1
DRIVE MOTOR
M2
DRIVE MECHANISM
352
DRIVE MOTOR
352a
310
HALF FOLDING SECTION
320
CONVEYANCE MECHANISM
340
ACCUMULATING SECTION
TRIMMING SECTION
370
EJECTING SECTION
380

FIG. 11

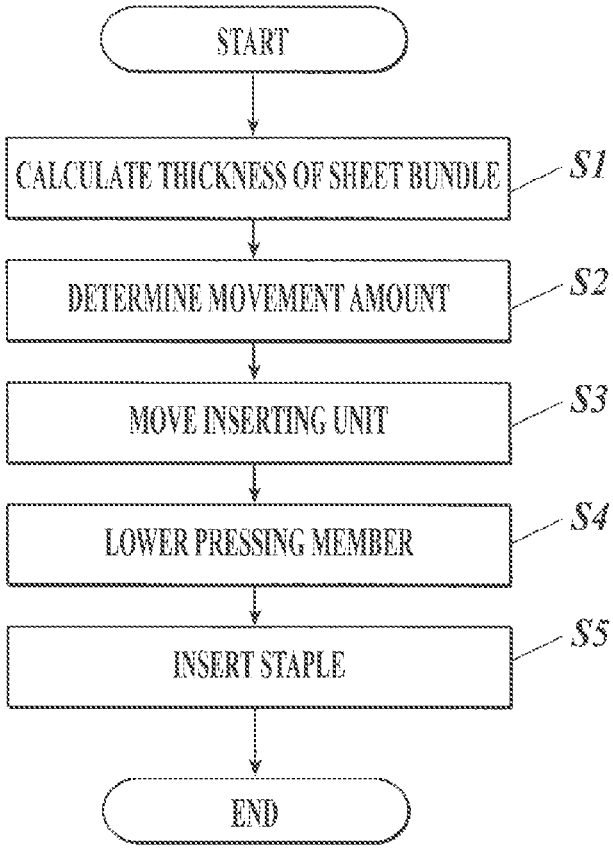

START
CALCULATE THICKNESS OF SHEET BUNDLE
S1
DETERMINE MOVEMENT AMOUNT
S2
MOVE INSERTING UNIT
S3
LOWER PRESSING MEMBER
S4
INSERT STAPLE
S5
END

FIG. 12

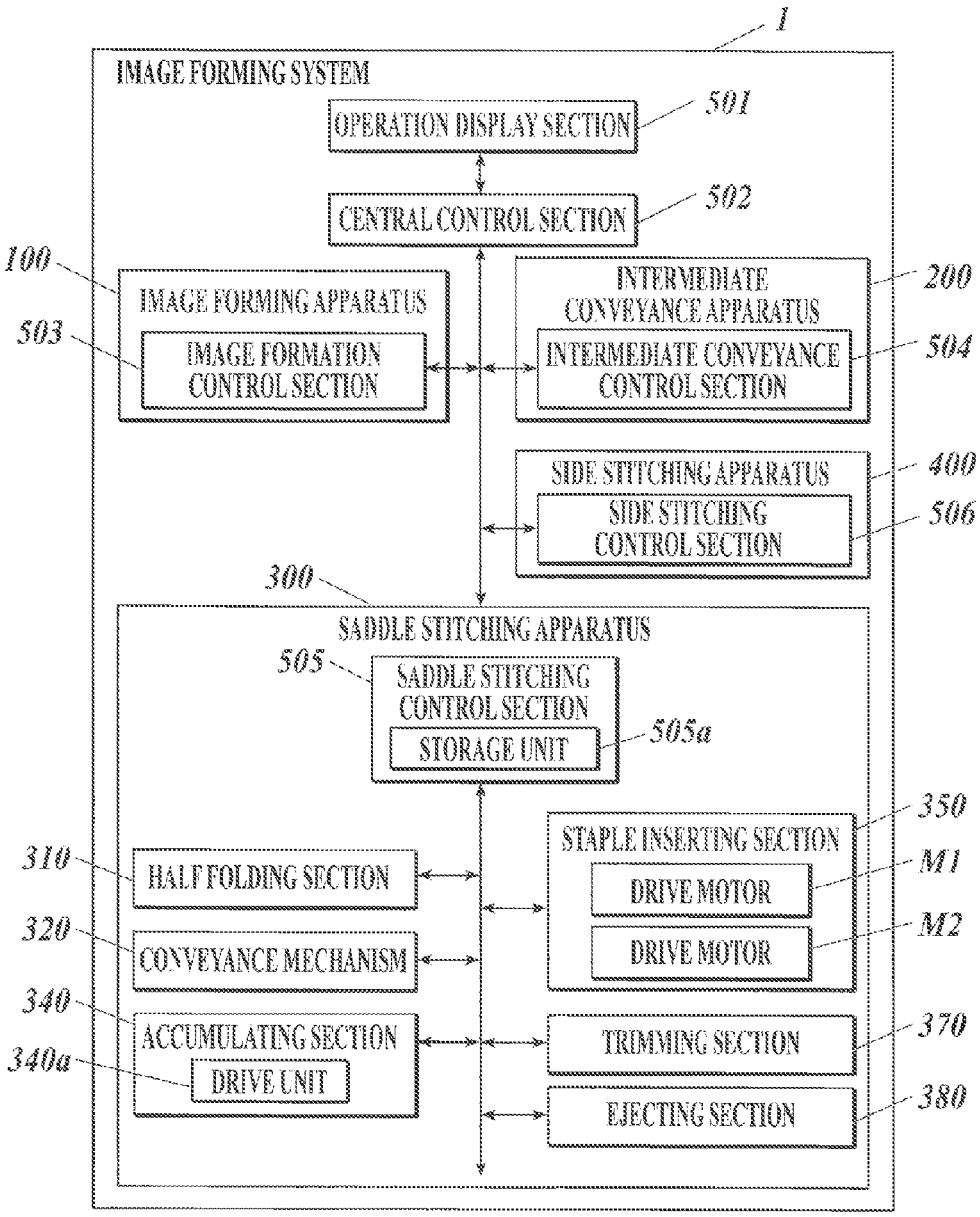
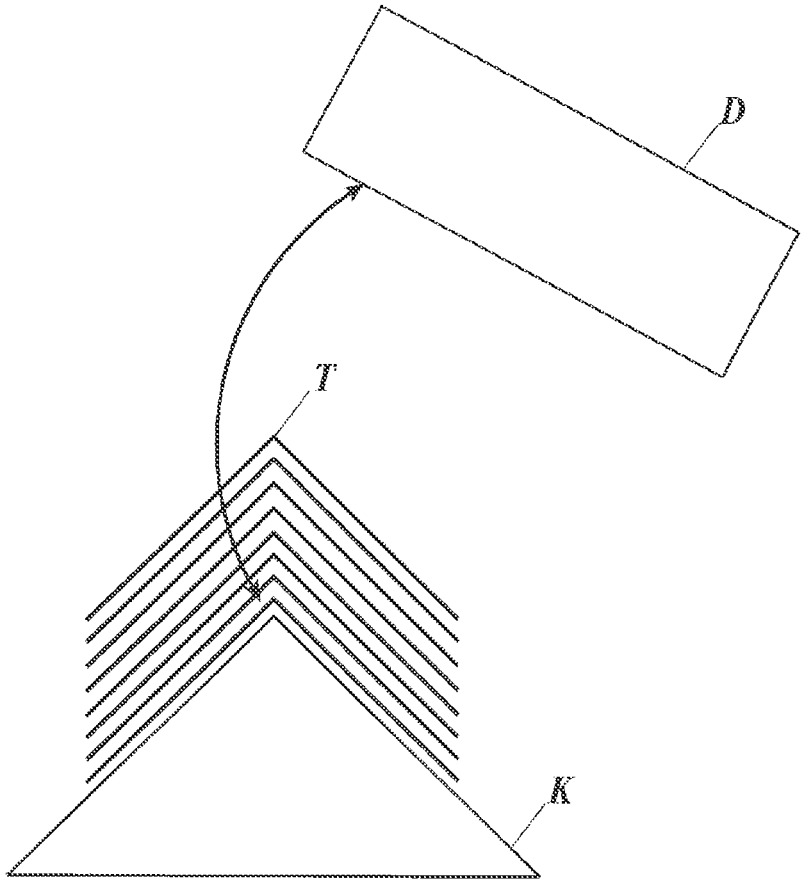

1
IMAGE FORMING SYSTEM
OPERATION DISPLAY SECTION
501
CENTRAL CONTROL SECTION
502
100
IMAGE FORMING APPARATUS
503
IMAGE FORMATION CONTROL SECTION
INTERMEDIATE CONVEYANCE APPARATUS
200
INTERMEDIATE CONVEYANCE CONTROL SECTION
504
SIDE STITCHING APPARATUS
400
SIDE STITCHING CONTROL SECTION
506
300
SADDLE STITCHING APPARATUS
505
SADDLE STITCHING CONTROL SECTION
STORAGE UNIT
505a
350
STAPLE INSERTING SECTION
310
HALF FOLDING SECTION
DRIVE MOTOR
M1
320
CONVEYANCE MECHANISM
DRIVE MOTOR
M2
340
ACCUMULATING SECTION
340a
DRIVE UNIT
TRIMMING SECTION
370
EJECTING SECTION
380

FIG.13



SHEET PROCESSING APPARATUS AND IMAGE FORMING SYSTEM

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates to a sheet processing apparatus and an image forming system.

2. Description of Related Art

There are known some conventional sheet processing apparatuses each of which forms a booklet with a saddle stitching section including a saddle unit to sequentially accumulate sheets of paper that are mountain-folded along middle folding lines so as to straddle the saddle unit, a staple inserting unit to insert a staple from above into the folding lines of the sheets accumulated on the saddle unit and a staple receiving unit which is provided to face the staple inserting unit across the sheets and receives and bends the ends of the staples inserted by the staple inserting unit (for example, see Japanese Patent Application Laid Open Publication No. 2005-41661).

In Japanese Patent Application Laid Open Publication No. 2005-41661, the staple receiving unit is built in the saddle unit and configured to protrude upward from the top of the saddle unit when the staple inserting unit puts a staple through a sheet.

However, such configuration has a problem that the staple receiving unit is moved upward less stably when a larger number of sheets are accumulated and thus the staple is inserted at a less accurate position.

Against the above problem, there has been suggested a configuration in which the staple receiving unit is fixed inside the saddle unit, the top of the staple receiving unit is located at the top of the saddle unit and the staple inserting unit moves so as to make an arc (hereinafter, called are motion) toward the saddle unit and the staple receiving unit (for example, see Japanese Patent Application Laid Open Publication No. H9-216764).

Such staple inserting unit which makes an arc motion is also used for side stitching processing to put staples into unfolded sheets.

However, since the staple inserting unit makes an are motion, as shown in FIG. **13**, the above Japanese Patent Application Laid Open Publication No. H9-216764 has a problem that the staple inserting unit D makes the arc motion with the orbit out of the ridge line at the top of the upmost sheet in the sheet bundle depending on the thickness of the sheet bundle accumulated on the saddle unit K, and thus the staple is inserted at a position (stapling position) shifted from the folding line on the upmost sheet, that is, a desired position.

Such problem also possibly occurs in the side stitching processing.

SUMMARY OF THE INVENTION

The present invention has been made in consideration of the above problems in conventional techniques, and an object of the present invention is to provide a sheet processing apparatus and an image forming system which enables accurate stapling at a desired position regardless of the thickness of the accumulated sheet bundle.

In order to achieve the above object, according to one aspect of the present invention, there is provided a sheet processing apparatus including: an accumulating section on which a sheet is accumulated; a staple inserting section which is provided above the accumulating section; a staple receiving section which is provided so as to face the staple inserting section across a sheet bundle accumulated on the accumulating section; and a movement section which moves an inserting unit or the accumulating section according to a thickness of the sheet bundle so that the inserting unit faces a predetermined position on an upmost sheet of the sheet bundle, wherein the staple inserting section includes the inserting unit which inserts a staple into the sheet bundle by rotating toward the sheet bundle.

Preferably, in the sheet processing apparatus, the accumulating section includes a saddle unit on which a mountain-folded sheet folded along a folding line at a middle portion is accumulated so as to straddle the saddle unit, the staple receiving section is fixed inside the saddle unit so as to locate an upper part thereof at a top of the saddle unit, and the movement section moves the inserting unit or the saddle unit in a direction orthogonal to the folding line along a horizontal plane according to the thickness of the sheet bundle so that the inserting unit faces the folding line on the upmost sheet of the sheet bundle accumulated on the saddle unit.

Preferably, the sheet processing apparatus further includes a storage section in which movement information regarding the thickness of the sheet bundle and a movement amount of the inserting unit or the accumulating section is stored, and the movement section determines the movement amount of the inserting unit or the accumulating section on a basis of the movement information stored in the storage section.

Preferably, in the sheet processing apparatus, the inserting unit includes a biasing member which biases the inserting unit toward a base end portion thereof, and the movement section includes: a drive motor; a shaft member which is rotated by the drive motor; an eccentric cam which is connected to the shaft member; a push-out member which is provided so as to abut with the base end portion of the inserting unit and moves toward or away from the inserting unit in accordance with rotation of the eccentric cam; and a control unit which drives the drive motor.

Preferably, in the sheet processing apparatus, a supporting unit extending along a direction orthogonal to a movement direction of the inserting unit is provided near the inserting unit, the inserting unit includes: a main body which is rotated toward the sheet bundle; and a cover which is provided above the main body, and the cover includes a protruding portion which abuts with the supporting unit.

Preferably, in the sheet processing apparatus, an initial position of the inserting unit is set to a position thereof when the sheet bundle accumulated on the accumulating section has a largest thickness.

According to another aspect of the present invention, there is provided an image forming system, includes an image forming apparatus which forms an image on a sheet; and the sheet processing apparatus according to claim **1** which is connected to the image forming apparatus and performs saddle stitching that is stapling, along a middle folding line, the sheet having the image formed by the image forming apparatus.

BRIEF DESCRIPTION OF THE DRAWINGS

The above and other objects, advantages and features of the present invention will become more fully understood from the detailed description given hereinbelow and the appended drawings which are given by way of illustration only, and thus are not intended as a definition of the limits of the present invention, and wherein:

FIG. **1** is a schematic view illustrating the entire configuration of an image forming system;

FIG. **2** is a schematic view illustrating a configuration of a half folding section in a sheet processing apparatus as an example;

FIG. **3** is a perspective view illustrating a configuration of a conveyance mechanism in the sheet processing apparatus as an example;

FIG. **4** is a perspective view illustrating a configuration of a saddle stitching section in the sheet processing apparatus as an example;

FIG. **5** is a perspective view of a staple inserting section seen from the right rear; and

FIG. **6** is a lateral view of the staple inserting section seen from the right.

FIG. **7** is an enlarged view illustrating a front end portion of the staple inserting section;

FIG. **8** is a schematic view illustrating an inserting unit in the staple inserting section;

FIG. **9** is an enlarged view illustrating a receiving unit in a staple receiving section;

FIG. **10** is a block diagram showing a main configuration according to the operation control of the image forming system;

FIG. **11** is a flowchart showing operations of the staple inserting section in saddle stitching processing;

FIG. **12** is a block diagram showing another configuration of the image forming system; and

FIG. **13** is a view for explaining a problem in conventional techniques.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

An image forming system **1** according to an embodiment of the present invention will now be described with reference to the drawings.

FIG. **1** is a schematic view illustrating the entire configuration of the image forming system **1**.

The image forming system **1** includes an image forming apparatus **100**, an intermediate conveyance apparatus **200**, a saddle stitching apparatus **300** and a side stitching apparatus **400**.

In the following description, the vertical direction referred to as Z direction; the direction of an array of the image forming apparatus **100**, the intermediate conveyance apparatus **200**, the saddle stitching apparatus **300** and the side stitching apparatus **400** in FIG. **1** is referred to as X direction; and the direction orthogonal to both the X and Z directions is referred to as Y direction.

The X direction has front and rear sides and the Y direction has right and left sides. The front side is upstream and the rear side is downstream when a sheet is conveyed in the image forming system **1**. The right side is upstream and the left side is downstream when a sheet is conveyed in half folding and saddle stitching processing by the saddle stitching apparatus **300**.

The image forming apparatus **100** forms an image on a sheet of paper.

In specific, the image forming apparatus **100** for forming an image on a sheet includes, for example, a conveyance section to extract and convey a sheet from the sheets stored as recording media from a sheet tray, a developing section to develop a toner image based on bitmap data onto a first transfer member such as transfer roller, a first transfer section to transfer the toner image developed on the first transfer member onto a second transfer member such as transfer drum **150**, a second transfer section to transfer the toner image on the second transfer member onto the sheet conveyed by the conveyance section, a fixing section to fix the transferred toner image onto the sheet, and an ejecting section to eject the sheet after the fixation by the fixing section.

The image forming apparatus **100** passes the ejected sheet which has the image formed thereon to the intermediate conveyance apparatus **200**. That is, the connection in the image forming system **1** allows the sheet ejected from the image forming apparatus **100** to be passed to the intermediate conveyance apparatus **200**.

The intermediate conveyance apparatus **200** can temporarily stack a sheet and score and trim the sheet.

Specifically, the intermediate conveyance apparatus **200** includes, for example, a standby section (stacker) which conveys downward a sheet conveyed from the image forming apparatus **100** and makes the sheet stop once to standby with the sheet surface along the Z direction; an alignment section which aligns the position of the sheet during standby; a scoring section (creaser) which scores the aligned sheet; and a trimming section (slitter) which trims off margins in the sheet while the conveyance of the scored sheet.

That is, the intermediate conveyance apparatus **200** once stops the sheet passed from the image forming apparatus **100** at the standby section, aligns the sheet with the alignment section, scores the sheet with the scoring section, and thereafter trims the margins in the sheet with the trimming section while conveying the scored sheet. Then, the intermediate conveyance apparatus **200** passes the sheet with the margins trimmed off by the trimming section to the saddle stitching apparatus **300**.

The intermediate conveyance apparatus **200** can also pass the sheet received from the image forming apparatus **100** to the saddle stitching apparatus **300** without performing a part or all of the various processes by the intermediate conveyance apparatus **200**.

The saddle stitching apparatus **300** as a sheet processing apparatus performs half folding that is folding the sheet in half (in two), saddle stitching that is stapling a predetermined number of stacked half-folded sheets to create a saddle-stitched booklet, trimming that is trimming the end surfaces of the saddle-stitched booklet, and such like.

In specific, the saddle stitching apparatus **300** includes, for example, a half folding section **310** which folds the sheet received from the intermediate conveyance apparatus **200** in half along the Y direction, a conveyance mechanism **320** which conveys the sheet half-folded by the half folding section **310** in the direction (Y direction) along the folding line in the sheet, a saddle stitching section **330** which inserts staples into the sheet bundle to perform saddle stitching after overlying sheets conveyed from the conveyance mechanism **320**, a trimming section **370** which trims the end surfaces of the saddle-stitched sheet bundle, and an ejecting section **380** which ejects the saddle-stitched booklet having the trimmed end surfaces.

The saddle stitching apparatus **300** can also pass the sheet received from the intermediate conveyance apparatus **200** to the side stitching apparatus **400** without performing a part or all of the various processes by the saddle stitching apparatus **300**. The saddle stitching apparatus **300** may further include a processing section for square folding to form the spine of the saddle-stitched booklet.

FIG. **2** is a schematic view illustrating the configuration of the half folding section **310** as an example.

The half folding section **310** includes, for example, a conveyance unit **311** which conveys the sheet received from the image forming apparatus **100** to a predetermined position, a pair of half folding rollers **312***a* and **312***b* which is located above the sheet stopped at the predetermined position and a

plate-like folding knife **313** which is located below the pair of half folding rollers **312***a* and **312***b* and movable so as to come between the half folding rollers **312***an* and **312***b*.

The conveyance unit **311** conveys the sheet received from the image forming apparatus **100** downstream with the sheet surface in nearly parallel to the X-Y plane by a plurality of pairs of conveyance rollers **311***a*, and locks the end at downstream side in conveyance direction of the conveyed sheet to locate and stop the sheet at a predetermined position with a stopper **311***b* provided on the conveyance path.

The predetermined position is a position where the central portion in the X direction of the conveyed sheet face the folding knife **313**. In order to stop the sheet at such predetermined position, on, the position of the stopper **311***b* on the conveyance path is appropriately set according to the sheet size.

The half folding rollers **312***a* and **312***b* are cylindrical rollers provided to be rotatable and function as a nip unit along the Y direction by contacting each other at the outer circumferential surfaces.

The folding knife **313** is a plate like member provided along Y-Z plane. When the sheet is located between the pair of half folding rollers **312***a* and **312***b* and the folding knife **313**, the folding knife **313** comes between the half folding rollers **312***a* and **312***b*, and thereby presses the sheet into the nip unit. Thus, the sheet is folded in two so as to have a folding line along the Y direction at the position contacting the folding knife **313**. That is, the sheet is in what is called a mountain fold shape with the folding line up and the both ends down.

In such half folding process, a sheet may be folded one by one or every plurality of sheets may be folded (for example, every three sheets).

FIG. **3** is a perspective view illustrating the configuration of the conveyance mechanism **320** as an example.

The conveyance mechanism **320** includes two conveyance belts **321** and **321**, for example.

The two conveyance belts **321** and **321** are disposed so as to extend in the Y direction sandwiching the folding knife therebetween as shown in FIGS. **2** and **3**, and conveys the half-folded sheet in the direction (Y direction) along the folding line.

The two conveyance belts **321** and **321** start rotating after the sheet is folded in two by the folding knife **313** moving up and down in the Z direction.

Abutting portions **321***a* and **321***a* are fixed on the respective conveyance belts **321** and **321** so as to protrude from their surfaces. The abutting portions **321***a* and **321***a* on the conveyance belts **321** and **321** move according to the rotation of the conveyance belts **321** and **321** to abut with the back end in conveyance direction (right end) of the half-folded sheet, push the abutting sheet to the accumulating section **340** and thereafter return to the initial position not abutting the back end in conveyance direction of the sheet.

The half-folded sheet is conveyed to the after-mentioned accumulating section **340** in the saddle stitching section **330** by such conveyance mechanism **320**.

FIG. **4** is a perspective view illustrating the configuration of the saddle stitching section **330** as an example.

The saddle stitching section **330** includes an accumulating section **340** to overlie and accumulate sheets conveyed by the conveyance mechanism **320**, a staple inserting section **350** provided above the accumulating section **340**, a staple receiving section **360** provided inside the accumulating section **340** and a supporting section S to support the sections.

The supporting section S includes a base portion S**1** extending in the X direction and a standing portion S**2** provided to be vertical from a base end of the base portion S**1**. The accumulating section **340** and the staple receiving section **360** are provided at the front end of the base portion S**1** and the staple inserting section **350** is provided at the upper end of the standing portion S**2**.

The accumulating section **340** is provided next to the left end of the conveyance mechanism **320**.

The accumulating section **340** includes a saddle unit **341** to place the sheets conveyed by the conveyance mechanism **320**, for example.

The saddle unit **341** is in a convex shape with the top part at an angle of nearly 90 degrees, and mountain-folded sheets (mountain-shape sheets) which have been conveyed by the conveyance mechanism **320** are placed on the top part of the saddle unit **341** so as to straddle the saddle unit **341**.

When each of the sheets to form a booklet is half-folded, the sheet is ejected and sequentially placed on the saddle unit **341** so that the sheet which is innermost of the booklet to be formed is located lowest.

A cut-out portion **341***a* to expose the top part of the staple receiving section **360** fixed inside the saddle unit **341** is formed at the left end of the top part of the saddle unit **341**, and the upper portion of the staple receiving section **360** is located at the top of the saddle unit **341**.

Though not shown in the drawings, a front end alignment unit which abuts with the front end in conveyance direction of the sheet advancing from right to left on the saddle unit **341** and stops the sheet is provided downstream of the saddle unit **341** in the sheet conveyance direction.

It is also preferable that a back end alignment unit movable in the Y direction along the top ridge line of the saddle unit **341** is provided at the right end of the top part of the saddle unit **341**. When the sheet is placed on the saddle unit **341**, the back end alignment unit lightly hits the back end in conveyance direction of the sheet by reciprocating in the Y direction along the top part ridge line of the saddle unit **341** to align the sheet in the conveyance direction.

FIG. **5** is a perspective view of the staple inserting section **350** seen from the right rear. FIG. **6** is a lateral view of the staple inserting section **350** in FIG. **5** seen from the right FIG. **7** is an enlarged view illustrating the front end of the staple inserting section **350**. FIG. **8** is a schematic view illustrating an inserting unit **351** in the staple inserting section **350**.

In FIGS. **5** to **7**, the illustration of right lateral wall **353** in the inserting unit **351** is omitted.

The staple inserting section **350** includes an inserting unit **351** to put a staple into the sheets placed on the saddle unit **341**, for example.

The inserting unit **351** includes a main body **351***a* containing staples and a cover **351***b* covering the top part of the main body **351***a*, and the rear end of the inserting unit **351** is supported by the standing portion S**2**.

The main body **351***a* and the cover **351***b* move in the X direction in an integrated manner, and when inserting a staple, only the main body **351***a* is rotated.

A drive mechanism **352** to drive the inserting unit **351** in the X direction is provided at the rear side of the inserting unit **351**.

Lateral walls **353** and **353** are respectively provided at the left and right sides of the inserting unit **351**.

A supporting unit **354** supported by the lateral walls **353** and **353** at the ends thereof is provided in the front side above the inserting unit **351** so as to extend along the Y direction.

The main body **351***a* includes a feeding port (not shown in the drawings) at the lower surface of the front end, and feeds a staple through the feeding port when abutting with the sheet.

Specifically, the main body **351***a* is driven by a drive motor M1 (see FIG. **10**) to rotate in the arrow A direction in FIG. **6** around a rotation shaft G1.

Extending plates **351***c* and **351***c* extending laterally from the respective lateral surfaces are provided at the front part of the cover **352***b*, and the extending plates **351***c* and **351***c* respectively include biasing members **355** and **355** which bias the inserting unit **351** backward.

The biasing members **355** and **355** are pull-type coil springs, for example, and bias the inserting unit **351** backward in a state in which the front ends thereof are connected to the top parts of the respective extending plates **351***c* and **351***c* and the rear ends thereof are connected to the supporting unit **354**.

A protruding portion **351***d* protruding upward is provided on the upper surface of the cover **351***b*, and the protruding portion **351***d* is maintained abutting with the rear end of the lower part in the supporting unit **354**.

The protruding portion **351***d* functions as a stopper for preventing the cover **351***b* and the inserting unit **351** from plunging forward due to the impulse when the main body **351***a* is rotated around the rotation shaft G1 to provide a staple.

The drive mechanism **352** includes a drive motor **352***a*, a shaft **352***b* which is rotated by the drive motor **352***a*, eccentric cams **352***c* connected to the shaft **352***b* and a push-out member **352***d* abutting with the rear side of the main body **351***a*, for example. The drive mechanism **352** functions as a movement section together with a saddle stitching control section **505** (described later).

The drive motor **352***a* is a pulse motor such as step motor, for example, and by the control of the saddle stitching control section **505**, drives a rotor to make a step movement forward or backward by a predetermined angle. Thus, a rotation drive force is provided to a drive force transmitting section not shown in the drawings, and the drive force transmitting section rotates the shaft **352***b*.

The shaft **352***b* is provided at the rear side of the inserting unit **351** (main body **351***a*) so as to extend in the Y direction. The shaft **352***b* is rotated according to the drive of the drive motor **352***a*. The shaft **352***b* includes two eccentric cams **352***c*.

Each of the eccentric cams **352***c* is formed in a nearly circle shape, and the shaft **352***b* penetrates positions slightly shifted from the centers of the eccentric cams **352***c*. The eccentric cams **352***c* are rotated forward or backward by a predetermined angle by the shaft **352***b* being rotated according to the drive of the drive motor **352***a*.

The push-out member **352***d* abuts with the eccentric cams **352***c*. The push-out member **352***d* is, for example, supported by a shaft receiver (not shown in the drawings) with a long hole extending in the X direction, and can move in the X direction.

The push-out member **352***d* moves forward by the eccentric cams **352***c* being rotated forward by the predetermined angle. Thus, the main body **351***a* and the inserting unit **351** move forward against the biasing force by the biasing members **355** and **355**.

The push-out member **352***d* moves backward by the eccentric cams **352***c* being rotated backward by the predetermined angle. Then, the main body **351***a* and the inserting unit **351** move backward by the biasing force of the biasing members **355** and **355**.

The staple inserting section **350** is provided with two pressing members **356** and **356** along the Y direction so as to sandwich the inserting unit **351** therebetween. The pressing members **356** and **356** are disposed at positions facing the supporting members **362** and **362** provided at the staple receiving section **360**.

When a predetermined number of sheets for a single booklet are placed on the saddle unit **341**, by the drive of a drive motor M2 (see FIG. **10**), arms **356***a* are rotated in the arrow A direction of FIG. **6** around the rotation shaft G2 to lower the pressing members **356** and **356** so that the pressing members **356** and **356** can press the sheets on die saddle unit **341** with the supporting members **362** and **362**.

Specifically, the biasing members **356** and **356** have a configuration that the rear ends of the arms **356***a* are biased upward by biasing members **356***b* such as pull-type coil springs and pressed downward by a cam mechanism not shown in the drawings or such like. When the predetermined number of sheets are placed on the saddle unit **341**, the press by the cam mechanism is released by the drive of the drive motor M2, and the rear ends of the arms **356***a* are pulled up to lower the front ends thereof.

After the pressing members **356** and **356** are lowered to press the sheets on the saddle unit **341** with the supporting members **362** and **362** in such way, the inserting unit **351** provides staples.

FIG. **9** is an enlarged view illustrating a receiving unit **361** in the staple receiving section **360**.

The staple receiving section **360** includes a receiving unit **361** provided inside the saddle unit **341** and two supporting members **362** and **362** disposed along the Y direction across the receiving unit **361**.

The receiving unit **361** is fixed inside the saddle unit **341**, and the top part thereof is exposed through the cut-out portion **341***a* in the saddle unit **341**. A concave portion **361***a* for abutting and bending the ends of the staple inserted by the inserting unit **351** is formed on the upper surface of the receiving unit **361**. That is, the ends of the staple pressed against, the sheets to penetrate the sheets by the inserting unit **351** are bent by abutting with the concave portion **361***a*.

Here, the width in the X direction of the concave portion **361***a* is set to be 2.3 mm, for example.

Generally, the width in the X direction of the concave portion **361***a* is approximately 0.2 mm which is slightly larger than the width of the staple; however, the embodiment sets a larger width in the X direction of the concave portion **361***a* since the inserting unit **351** moves in the X direction. Thus the ends of the staple can surely abut with the concave portion **361***a*.

Though the width in the X direction of the concave portion **361***a* is set to be 2.3 mm in the embodiment for the above reason, the width in the X direction of the concave portion **361***a* can be appropriately changed as long as it is larger than 0.2 mm and equal to or less than 2.3 mm. By setting the width in the X direction of the concave portion **361***a* equal to or less than 2.3 mm, staple buckling can be prevented.

The supporting members **362** and **362** are provided along the Y direction across the receiving unit **361**. The supporting members **362** and **362** are provided at positions facing the pressing members **356** and **356** in the staple inserting section **350**, and sandwich the sheets with the pressing members **356** and **356** when the pressing members **356** and **356** are lowered.

Specifically, the upper ends of the supporting members **362** and **362** protrude from the upper surface of the receiving unit **361**, and the supporting members **362** and **362** are supported by the spring members **362***a* biasing the supporting members **362** and **362** so as to protrude upward. When the pressing members **356** and **356** are lowered, the supporting members **362** and **362** are withdrawn downward by the press from the pressing members **356** and **356**.

Thus, the supporting members **362** and **362** can press the top part ridge line of the sheets to be flat with the pressing members **356** and **356**, and nearly flatten the folding line in the top part of the sheets to be stapled by the inserting unit **351**.

The trimming section **370** trims the end surfaces of the booklet which has been saddle-stitched as described above. That is, the trimming section **370** performs trimming to align the end surfaces since the end surfaces of such saddle-stitched booklet are not aligned depending on the number of sheets forming the booklet.

The electing section **380** ejects the booklet having the end surfaces trimmed by the trimming section **370**.

Returning to FIG. **1**, the side stitching apparatus **400** performs side stitching to a plurality of sheets.

Specifically, the side stitching apparatus **400** includes, for example, a stapling section to staple a plurality of sheets received from the saddle stitching apparatus **300**, a page end trimming section to trim a part of end portions of the plurality of stapled sheets so as to align the end portions which are parallel to the spine, and an ejecting section to eject the sheets which have been processed by the connected apparatuses.

The side stitching apparatus **400** can eject the sheets received from the saddle stitching apparatus **300** without performing a part or all of the various processes by the side stitching apparatus **400**.

Next, the operation control of the image forming system **1** will be described.

FIG. **10** is a block diagram showing the main configuration according to the operation control in the image forming system **1**.

The image forming system **1** includes an operation display section **501** which receives input operation from a user according to the operation of the image forming system **1** and performs display according to the operation of the image forming system **1**, a central control section **502** which controls operations of the entire image forming system **1**, an image formation control section **503** which controls operations of the image forming apparatus **100**, an intermediate conveyance control section **504** which controls operations of the intermediate conveyance apparatus **200**, a saddle stitching control section **505** which controls operations of the saddle stitching apparatus **300** and a side stitching control section **506** which controls operations of the side stitching apparatus **400**.

The operation display section **501** includes, for example, a touch panel type operation display unit or switches and keys for various types of input to send a signal according to the input from the user to the central control section **502**.

Each of the central control section **502**, the image formation control section **503**, the intermediate conveyance control section **504** and the side stitching control section **506** includes a CPU (Central Processing Unit), a RAM (Random Access Memory), a storage unit and such like to read out a software program and various types of data according to processing and execute the processing.

Similarly, the saddle stitching control section **505** also includes a CPU, a RAM, a storage unit **505***a* and such like to read out a software program and various types of data according to processing and execute the processing.

The storage unit **505***a* is a non-volatile memory which is readable and writable.

In response to the input from the user via the operation display section **501**, the central control section **502** sets various types of conditions according to the image forming system **1** such as sheet size and the number of colors to form images (for example, full-color, gray scale or monochrome), the number of sheets in a single booklet to be saddle-stitched, whether to trim the end portions which are margins, the width of the end portions to be trimmed and nip pressure in the half folding processing. Then, the central control section **502** outputs instructions to perform the processing according to the setting to the image formation control section **503**, the intermediate conveyance control section **504**, the saddle stitching control section **505** and the side stitching control section **506**. The control sections control operations of the respective apparatuses to be controlled according to the instructions.

For example, the central control section **502** outputs an instruction for performing half folding and saddle stitching to the saddle stitching control section **505**.

In response to this, the saddle stitching control section **505** controls the half folding section **310** to perform half folding and controls the saddle stitching section **330** to perform saddle stitching.

The saddle stitching is executed according to the setting condition set by the user operating the operation display section **501**. The setting condition includes, for example, the number and position of staples to be put into the sheets along the folding line in addition to the type, basis weight and the number of sheets to be saddle stitched.

The saddle stitching control section **505** determines the movement amount of the inserting unit **351** when performing saddle stitching on the basis of the thickness of a sheet bundle according to the setting condition.

At this time, the saddle stitching control section **505** refers to the storage unit **505***a*.

As movement information, a table associating the thickness of the sheet bundle accumulated on the saddle unit **341** with the movement amount of the inserting unit **351** is stored in the storage unit **505***a*, for example.

The saddle stitching control section **505** calculates the thickness of the sheet bundle according to the setting condition (type, basis weight and the number of sheets) and refers to the table stored in the storage unit **505***a* to determine the movement amount of the inserting unit **351** according to the thickness of the sheet bundle.

The movement amount is a distance that the inserting unit **351** moves from a predetermined reference position. The movement amount is indicated with a positive numeral value when the inserting unit **351** moves forward from the predetermined reference position and indicated with a negative numeral value when the inserting unit **351** moves backward from the predetermined reference position, for example.

The position where the inserting unit **351** is to be located when the sheet bundle has the largest thickness is used as the predetermined reference position, for example.

The position of the inserting unit **351** as initial setting is set according to the largest thickness of the sheet bundle. That is, as initial setting, the inserting unit **351** is located at the position where the staple can penetrate straight through the sheet bundle and have the largest inserting force when the sheet bundle has the largest thickness.

Such initial setting enables the inserting unit **351** move for a smaller distance when the sheet bundle has a larger thickness, makes the position setting harder to shift, and thus can reduce the concern of staple buckling.

An arithmetic expression for calculating the movement amount of the inserting unit from the sheet type, basis weight and the number of sheets may be stored in advance as the movement information in addition to the table.

Next, operations of the staple inserting section **350** in the saddle stitching by the saddle stitching apparatus **300** will be described.

FIG. **11** is a flowchart showing operations of the staple inserting section **350** in the saddle stitching.

Before starting the saddle stitching, the saddle stitching control section **505** sequentially half-folds the predetermined number of sheets to form a booklet with the half folding section **310**, and sequentially conveys the half-folded sheets onto the saddle unit **341** in the accumulating section **340** with the conveyance mechanism **320**.

When the sheets are conveyed onto the saddle unit **341** in the accumulating section **340**, the saddle stitching control section **505** controls so that the staple inserting section **350** is located away from the accumulating section **340** and the staple receiving section **360**.

The saddle stitching control section **505** first calculates the thickness of the sheet bundle on the basis of the setting condition (step S**1**).

Specifically, the saddle stitching control section **505** calculates the thickness of the sheet bundle accumulated on the saddle unit **341** on the basis of the setting condition (type, basis weight and the number of sheets to be saddle stitched).

Then, the saddle stitching control section **505** determines the movement amount according to the thickness of the sheet bundle (step S**2**).

Specifically, the saddle stitching control section **505** refers to the storage unit **505***a* and determines the movement amount according to the thickness of the sheet bundle calculated in step S**1**.

Next, the saddle stitching control section **505** moves the inserting unit **351** (step S**3**).

Specifically, the saddle stitching control section **505** drives the drive motor **352***a* to rotate the eccentric cams **352***c* by a predetermined angle and moves the push-out member **352***d* to move the inserting unit **351** (main body **351***a* and cover **351***b*) by the determined movement amount.

Next, the saddle stitching control section **505** lowers the pressing members **356** and **356** to sandwich the sheet bundle with the supporting members **362** and **362** (step S**4**).

Specifically, the saddle stitching control section **505** drives the drive motor M**2** to rotate the arm **356** around the rotation shaft G**2**, and thereby lowers the pressing members **356** and **356** to sandwich the sheets on the saddle unit **341** with the supporting members **362** and **362**.

Next, the saddle stitching control section **505** inserts staples with the main body **351***a* in the inserting unit **351** (step S**5**).

Specifically, the saddle stitching control section **505** drives the drive motor M**1** to rotate the main body **351***a* in the inserting unit **351** around the rotation shaft G**1** and provides a staple from the feeding port to insert the staple into the sheets.

As described above, in the embodiment, the movement section (drive mechanism **352** and saddle stitching control section **505**) moves the inserting unit **351** in the direction orthogonal to the folding line along the horizontal plane according to the thickness of the sheet bundle so that the inserting unit **351** faces the folding line on the upmost sheet of the sheet bundle accumulated on the saddle unit **341**.

Thus, stapling can be accurately performed at the desired position (the folding line on the upmost sheet of the sheet bundle) of the sheets regardless of the number of sheets accumulated on the saddle unit **341**.

This can obtain a good appearance of the booklet after the stapling.

The embodiment includes the storage unit **505***a* to store the table as movement information regarding the thickness of sheet bundle and the movement amount of the inserting unit **351**, and the movement section determines the movement amount of the inserting unit **351** on the basis of the movement information stored in the storage unit **505***a*.

Thus, the movement amount can be determined on the basis of the movement information which has been stored in advance.

In the embodiment, the inserting unit **351** includes biasing members **355** and **355** to bias the inserting unit **351** toward the base end portion thereof. The movement section includes the drive motor **352***a*, the shaft **352***b* which is rotated by the drive motor **352***a*, the eccentric cams **352***c* connected to the shaft **352***b*, the push-out member **352***d* which is provided to abut with the base end portion of the inserting unit **351** and move toward or away from the inserting unit **351** in accordance with the rotation of the eccentric cams **352***c*, and the saddle stitching control section **505** which drives the drive motor **352***a*.

Thus, the inserting unit **351** can be moved in the X direction by a simple configuration.

In the embodiment, the supporting unit **354** extending in the direction orthogonal to the movement direction of the inserting unit **351** is provided near the inserting unit **351**. The inserting unit **351** includes the main body **351***a* which is rotated toward the sheet bundle and the cover **351***b* provided above the main body **351***a*, and the cover **351***b* includes the protruding portion **351***d* abutting with the supporting unit **354**.

Thus, since the protruding portion **351***d* abuts with the supporting unit **354** when the main body **351***a* is rotated to staple the sheet bundle, it is possible to prevent the inserting unit **351** from plunging out forward due to the impulse of rotation when a staple is inserted into the sheet bundle.

In the embodiment, the initial position of the inserting unit **351** is set to be the position where the inserting unit **351** is to be located when the sheet bundle accumulated on the accumulating section has the largest thickness.

Thus, the inserting unit **351** is moved for a smaller distance when the sheet bundle has a larger thickness, the setting is difficult to shift, and the concern of the staple buckling can be reduced.

Though the embodiment has been described by illustrating a configuration in which the inserting unit **351** is moved, the inserting unit **351** may be fixed and the saddle unit **341** may be moved in the X direction. In such case, as shown in FIG. **12**, the staple inserting section **350** does not include the drive mechanism **352**, and the accumulating section **340** includes the drive unit **340***a* to move the saddle unit **341** in the X direction. The table associating the thickness of the sheet bundle with the movement amount of the accumulating section **340** is stored as movement information in the storage unit **505***a*, for example, and the movement section determines the movement amount of the accumulating section **340** on the basis of the movement information stored in the storage unit **505***a*.

Though the embodiment has been described by illustrating the configuration in which the inserting unit **351** is moved in the X direction by the drive mechanism **352**, a drive unit which drives the standing portion S**2** in the X direction may be provided instead of the drive mechanism **352**.

A drive section which inclines the saddle unit **341** may be provided instead of the drive mechanism **352** so that the sheets are accumulated on the saddle unit **341** with the folding lines forming a circular pattern in a sectional view by inclining the saddle unit **341** with the drive section.

Though the embodiment has been described by illustrating the saddle stitching apparatus **300** which performs saddle stitching to half-folded sheets as the sheet processing appa-

ratus, the sheet processing apparatus may be an apparatus (side stitching apparatus) which performs side stitching to staple unfolded sheets.

For example, the stapling section of the side stitching apparatus **400** in the embodiment may include an accumulating section to accumulate unfolded sheets, a staple inserting section **350** provided above the accumulating section, and a staple receiving section **350** which is provided at a position facing the staple inserting section **350** so as to sandwich the sheet bundle accumulated on the accumulating section therebetween. In such case, the drive mechanism **352** and the side stitching control section **506** as a movement section moves the inserting unit **351** or the accumulating section so that the inserting unit **351** in the staple inserting section **350** faces a predetermined position on the upmost sheet of the sheet bundle.

The entire disclosure of Japanese Patent Application No. 2013-139588 filed on Jul. 3, 2013 including description, claims, drawings, and abstract are incorporated herein by reference in its entirety.

What is claimed is:

1. A sheet processing apparatus comprising:

an accumulating section including a saddle unit on which a sheet is accumulated;

a staple inserting section which is provided above the accumulating section and includes an inserting unit which inserts a staple into a sheet bundle by rotating toward the sheet bundle;

a staple receiving section which is provided so as to face the staple inserting section across the sheet bundle accumulated on the accumulating section, the sheet bundle being accumulated on the saddle unit over the staple receiving section; and

a movement section which inclines the saddle unit of the accumulating section to an inclined state according to a thickness of the sheet bundle so that stapling is performed to the sheet bundle on the saddle unit while maintaining the inclined state of the saddle unit.

2. The sheet processing apparatus according to claim **1**, wherein

a mountain-folded sheet folded along a folding line at a middle portion is accumulated on the saddle unit so as to straddle the saddle unit,

the staple receiving section is fixed inside the saddle unit so as to locate an upper part thereof at a top of the saddle unit, and

the movement section moves the saddle unit in a direction orthogonal to the folding line along a horizontal plane according to the thickness of the sheet bundle so that the inserting unit faces the folding line on the upmost sheet of the sheet bundle accumulated on the saddle unit.

3. The sheet processing apparatus according to claim **1**, further comprising a storage section in which movement information regarding the thickness of the sheet bundle and a movement amount of the accumulating section is stored,

wherein

the movement section determines the movement amount of the accumulating section on a basis of the movement information stored in the storage section.

4. An image forming system, comprising:

an image forming apparatus which forms an image on a sheet; and

the sheet processing apparatus according to claim **1** which is connected to the image forming apparatus and performs saddle stitching that is stapling, along a middle folding line, the sheet having the image formed by the image forming apparatus.

5. The sheet processing apparatus according to claim **1**, wherein the movement section inclines the saddle unit such that stapling is performed at a fixed position relative to the uppermost sheet of the sheet bundle regardless of the thickness of the sheet bundle.

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